



FT-80 / Function description

The FT-80 transfer system is a fully automatic, compact unit with a straightforward design that manufactures high-quality, completely finished Bonnell innerspring units.

In four processing steps, the wire, which is fed from the swift, is processed into a spring. After the coiling process, the springs are placed into a star-shaped, 6-arm transport wheel and are gradually advanced to the next step. On the front side, the spring ends are knotted into end rings and then heat-treated between two electrodes. This heating to approx. 300° C relieves the spring from the stress of the coiling process and therefore reduces the setting loss. The finished springs are moved to the conveyor channel and are gradually advanced. The feed rate corresponds to the spring spacing within the spring unit. During transport, the springs are turned from the horizontal to the vertical position. After the programmed unit width has been reached, i.e., the required number of springs has been loaded, the row will be pushed by a loading slider into the jaws of the assembly machine. Using a helical feeder on the left side, one row after the other is tied into an innerspring unit. The innerspring unit ejection on the operator side allows for optimal handling by the operator.

The FT-80 consists of:

- Swift with wire monitor for up to max. 1,000 kg of wire
- Coiling machine
- Geneva Motion Unit with 6 arms
- Upper and lower knotting unit
- Heat treatment station
- Conveyor channel
- Insertion unit with loading slider
- 2 swifts for helical wire
- Wire feeds with two helical coiling machines
- Helical cutting tools
- Upper and lower knuckling devices (end jaws)
- Forward-facing innerspring unit table



Advantages / Special features:

- No compressed air
- Adjustable knot direction for easy adjustment of the spring diameter
- Total of 18 standard jaws; **each jaw** can be used as a knuckling device
- Very flexible unit width settings

Options:

- Additional pairs of jaws available
- Conversion kit for springs with 4, 5 and 6 coils
- Flexible swift positions

FIDES

PRODUCTION:

FIDES S.r.l.

Via A. Righi 22

47122 Forlì

Italy

Phone +39 0543 722063

Fax +39 0543 725230

info@fidessrl.eu

Spühl

SALES:

Spühl AG

Grüntalstrasse 23

9300 Wittenbach

Switzerland

Phone +41 71 292 13 12

Fax +41 71 292 11 24

www.spuhl.ch

saleswfm@spuhl.ch



Spring coiling section



Knotting machine with separate servomotor



Controller



Jaw holder



Innerspring unit release toward front